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C10-27-4-1
Job Sheet 188651



Part No: C10-27-4-1

Job Qty: 5 pcs

DAS
21
9-29

Part Name: Top Ring



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/14/19

Job Tracking No:

Due Date: 1/22/19

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG C10-27-4-1 Rev 4 IPP REV A RQ 17.09.01 VERIFIED BY DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	5 pcs	1/22/19		0.00	0.00	Small Fab - 1		TB
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
125	QC 5	5 pcs	1/22/19		0.00	0.00	QC 5 - 10		CL
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
					0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		



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Container No: S172892



Part: C10-27-4-1

Job No: 188651

Serial No/Batch: S172892

Revision: 4

Inspector:

Exp Date:

Instructions:

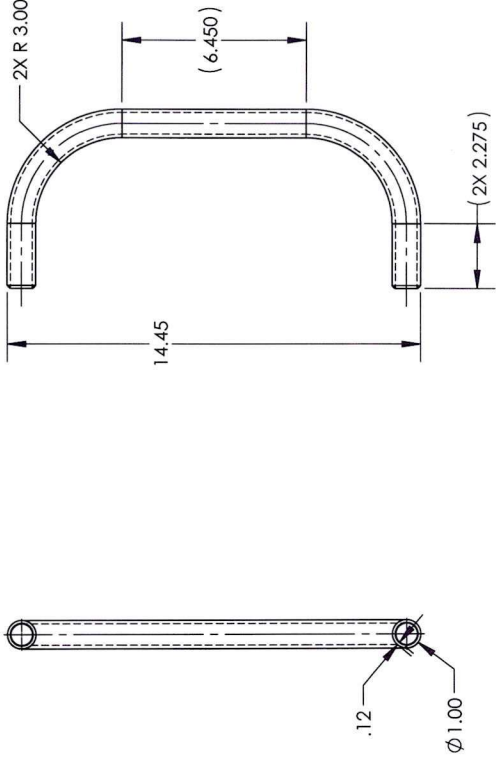
Date: 04/16/19

				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	EL
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
230 QC 21 - SA	5 pcs	1/22/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
Part Op 110 - (Small Fab) Cut tubing at 20" Bend as per dwg. Grind chamfers for welding. Descriptions: 125 - (QC5- Inspect part completeness to step on W/O) 220 - (Identify as per dwg & Stock Location: <u>W/200A CAGE3</u>) 230 - (QC21- Final Inspection - Work Order Release)					DAS 21 9-89 APR 16 2019
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
MT-A513-T-1.000W0.120	A513 Seamless Alloy Steel Round Tubing 1"dia. x 0.120" Wall	8.3300 ft (1.666 ea)	110-Small Fab - 1	5169077	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
110-Small Fab - 1	MT-A513-T-1.000W0.120	8	155	0	
Part Specifications					
Specifications could not be found.					

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REVISIONS

REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2		AS DRAWN BY APICAL	1/8/2013	JAG	
3		CHANGED FROM A FULL HOOP TO A HALF	1/8/2013	JAG	
4	16-0288	CHD DIM WAS 2X R3.00 & 2X R3.00 WAS 14.450 & 14.50. WAS 6.275 & 6.28. ADDED DIM (2X 2.275), (6.450), .12, Ø1.00. CHD DWG TO SHEET METAL TOLERANCE.	10/12/2016	RJC	JAG



DART
AEROSPACE

TOP RING

DWG NO.	C10-27-4-1	REV	4
MAT'L	CARBON STEEL CDS	UNLESS OTHERWISE SPECIFIED	
HEAT	1010	DIMENSIONS ARE IN INCHES	
TREAT	1010	XXX ± .010	
FINISH	1010	XX ± .005	
SPEC	1010	X ± .003	
DRAWN BY:	APICAL	ANGLES ± 1°	
CHECKED:	DUERFELDT	1. BREAK ALL SHARP EDGES	
OPPS APPR:	ANDERSON	2. 015 X .460 OR .518	
QA APPR:	LINDSAY	3. AFTER PLATING	
APPROVED:	GILBERT	3. INTERFERE WITH TOL PER ASME Y14.5M-2000	
SCALE	1:5	USED ON MODEL	
DATE	5/31/2002		
SHEET	1 OF 1		

ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS
		C10-27-4-1	1	TOP RING	CARBON STEEL CDS	